



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2530**  
**Job Sheet 205489**



Part No: D2530

Job Qty: 12 pcs

Part Name: Handle Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/20

Job Tracking No:

Due Date: 1/27/20

Created By: Jennifer Renwick

Type: Stock *SOLD STOCK*

Description:

Note: DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off           |
|-------|---------------------------|--------|------------|----------|-----------|---------|--------------------------|-----------|--------------------|
|       |                           |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |                    |
| 100   | Large Fab - Welded Assy-1 | 12 pcs | 1/27/20    | 1/27/20  | 0.12      | 2.33    | Large Fab - 1            |           | <i>MAC EL</i>      |
|       |                           |        |            |          |           |         | Large Fab - 10           |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 2            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 3            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 4            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 5            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 6            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 7            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 8            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 9            |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 11 (Various) |           |                    |
|       |                           |        |            |          |           |         | Large Fab - 12           |           |                    |
| 110   | QC 5                      | 12 pcs | 1/27/20    | 1/27/20  | 0.00      | 0.00    | QC 5 - 10                |           | <i>JAN 16 2020</i> |
|       |                           |        |            |          |           |         | QC 5 - 12                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 17                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 18                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 19                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 22                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 24                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 3                 |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 43                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 49                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 51                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 58                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 68                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 9                 |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 50                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 30                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 40                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 61                |           |                    |
|       |                           |        |            |          |           |         | QC 5 - 81                |           |                    |



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Container No: S247862



Part: D2530

Job No: 205489

Serial No/Batch: S247862

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/16/20

Plex 1/13/20 8:12 AM Dart.Renwick.Jennife

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JAN 23 2020

|                                 |        |         |           |                        |                 |
|---------------------------------|--------|---------|-----------|------------------------|-----------------|
|                                 |        |         |           | QC 3 - 40              |                 |
|                                 |        |         |           | QC 3 - 19              |                 |
|                                 |        |         |           | QC 3 - 43              |                 |
|                                 |        |         |           | QC 3 - 24              |                 |
|                                 |        |         |           | QC 3 - 61              |                 |
|                                 |        |         |           | QC 3 - 81              |                 |
| 170 Packaging 3-1 - Stock - B4B | 12 pcs | 1/27/20 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 2 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 3 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 4 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 5 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 6 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 7 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 8 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 9 - B4B  |                 |
|                                 |        |         |           | Packaging 3 - 10 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 11 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 12 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 13 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 14 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 15 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 16 - B4B | BEB20-01-23     |
|                                 |        |         |           | Packaging 3 - 17 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 18 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 19 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 20 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 21 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 22 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 23 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 24 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 25 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 26 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 27 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 28 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 29 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 30 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 31 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 32 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 33 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 34 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 35 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 36 - B4B |                 |
|                                 |        |         |           | Packaging 3 - 37 - B4B |                 |
| 180 QC 21 - SA                  | 12 pcs | 1/27/20 | 0.00 0.00 | QC 21 - SA - 21        | JAN 23 2020 DAS |
|                                 |        |         |           | QC 21 - SA - 70        | 70              |
|                                 |        |         |           | QC 21 - SA - 53        | 9-89            |

Part Op 100 - (Fabricate per Drwg) 1-Cut to length as per Dwg D2530

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

120 - 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME:

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

180 - (QC21- Final Inspection - Work Order Release)

Batch Rod: M139028

M166440  
230 015300 3:00

Mu# 013999

## Job BOM

| Part / Item      | Component Name              | Quantity              | Operation                          | Container      |
|------------------|-----------------------------|-----------------------|------------------------------------|----------------|
| M304TR0.750W.049 | 304 Round Tube .750 X .049W | 34.3800 ft (2.865 ea) | 100-Large Fab - Welded Assy-1      | 5244044        |
| D2534            | Lock Plate                  | 24 pcs (2 ea)         | 120-Large Fab - Welded Assy-2- B4B | 6X5202 984/18x |

Plex 1/13/20 8:12 AM Dart.Renwick.Jennifer

| Job Allocations                    |                  |          |           |           |
|------------------------------------|------------------|----------|-----------|-----------|
| Operation                          | Component Part   | Required | Inventory | Allocated |
| 100-Large Fab - Welded Assy-1      | M304TR0.750W.049 | 34       | 141       | 0         |
| 120-Large Fab - Welded Assy-2- B4B | D2534            | 24       | 55        | 0         |
| Part Specifications                |                  |          |           |           |
| Specifications could not be found. |                  |          |           |           |

Plex 1/13/20 8:12 AM Dart.Renwick.Jennifer

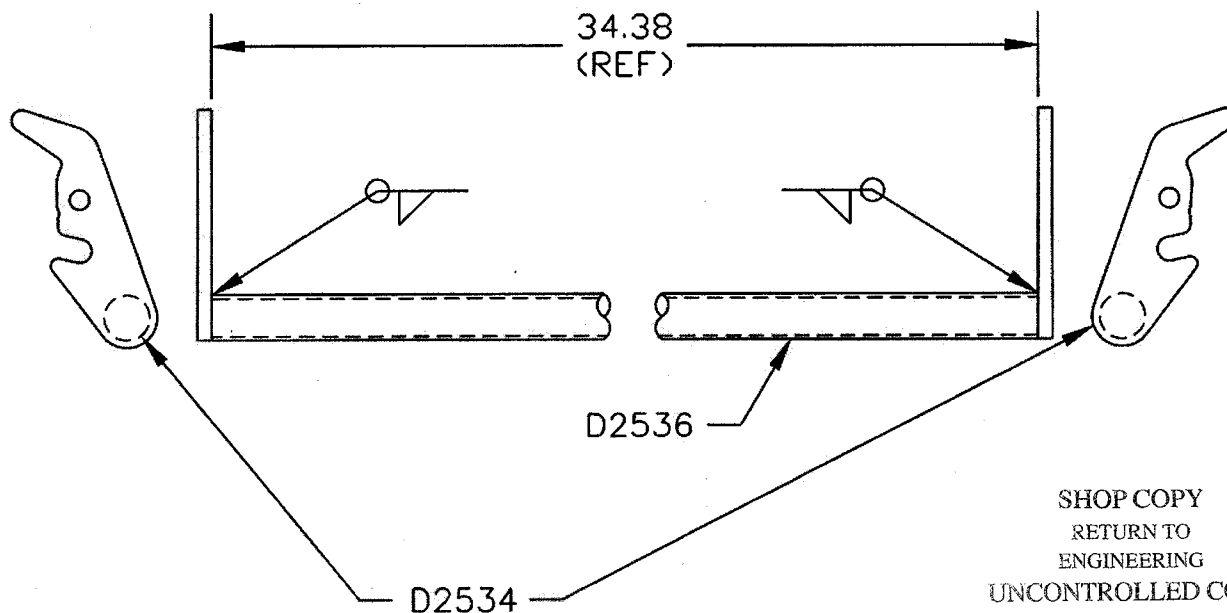
**DART**

|                               |                                |                                                              |                        |
|-------------------------------|--------------------------------|--------------------------------------------------------------|------------------------|
| DESIGN<br>B WILLIAMS          | DRAWN BY<br>PH                 | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2530                                         | REV. B<br>SHEET 1 OF 1 |
| DATE<br>04.12.14              |                                | TITLE<br>HANDLE WELDMENT                                     |                        |
| A                             | 96.06.18                       | NEW ISSUE                                                    |                        |
| B                             | 04.12.14                       | UPDATE NOTES AND DIMENSIONS                                  |                        |

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

| QTY | PART NUMBER | DESCRIPTION     |
|-----|-------------|-----------------|
| X   | D2530       | HANDLE WELDMENT |
| 1   | D2536       | HANDLE          |
| 2   | D2534       | LOCK PLATE      |



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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 205489

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |